



(19)

Europäisches Patentamt

European Patent Office

Offic européen des brevets



(11)

EP 1 070 596 A2

(12)

EUROPEAN PATENT APPLICATION

(43) Date of publication:
24.01.2001 Bulletin 2001/04(51) Int. Cl.⁷: B41J 11/00

(21) Application number: 00115238.8

(22) Date of filing: 13.07.2000

(84) Designated Contracting States:

AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU
MC NL PT SE

Designated Extension States:

AL LT LV MK RO SI

(30) Priority: 19.07.1999 US 357015

(71) Applicant: Xerox Corporation
Rochester, New York 14644 (US)

(72) Inventors:

- Roy, Joy
San Jose, California 95138 (US)
- Hadimoglu, Babur
Mountain View, California 94040 (US)

- Ellison, Richard N.
Palo Alto, California 94306 (US)
- Sprague, Robert
Saratoga, California 94303 (US)
- Kruger, James B.
Half Moon Bay, California 94019 (US)
- Lennon, John
Newark, California 94560 (US)

(74) Representative:

Grünecker, Kinkeldey,
Stockmair & Schwanhäusser
Anwaltssozietät
Maximilianstrasse 58
80538 München (DE)

(54) A method for achieving high quality aqueous ink-jet printing on plain paper at high print speeds

(57) An apparatus 30 for ink-jet printing on a recording medium 34 is provided which includes the steps of jetting aqueous ink drops 40 on the recording medium 34 (paper) in the form of an image. The aqueous ink used is a slow-drying (high-surface tension) ink 20 which does not penetrate the paper/paper fibers 34 for a relatively long time. Prior to penetration of the paper/paper fibers 34, the water in the droplet is quickly evaporated from the ink while still resident on the paper surface. The evaporation process is substantially com-

pleted prior to an additional liquid ink 20 being jetted 40 onto the same or adjoining location of the recording medium. The evaporation is rapid enough to prevent the resident ink from substantially migrating/wicking to any adjacent location or into the recording medium. Further drying energy (52, 54) is transferred to the resident ink spots from the same direction as the printheads ensuring less energy requirement.

FIG. 1A

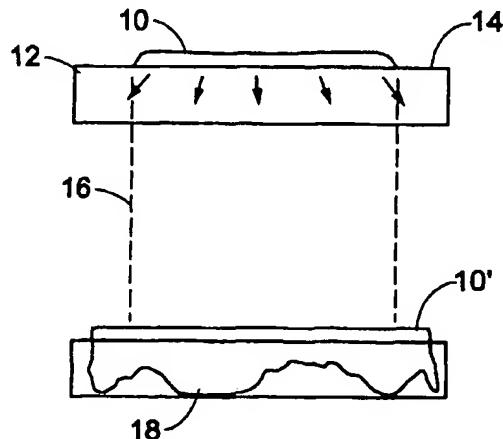


FIG. 1B



Description**Background of the Invention**

[0001] This invention relates generally to liquid ink-jet printers and more particularly to the use of high surface tension slow-drying ink which is dried in a manner to maintain high image quality. While not limited to, the present invention finds particular benefits when used in conjunction with acoustic ink printing.

[0002] Acoustic ink printing is a potentially important direct marking technology. It compares favorably with conventional ink-jet systems for printing either on plain paper or on specialized recording media while providing significant advantages of its own.

[0003] Drop-on-demand and continuous-stream ink-jet printing systems have experienced reliability problems because of their reliance on nozzles with small ink ejection orifices which easily clog and which limit the life as the size of an ejected ink droplet is decreased. Acoustic printing obviates the need for such nozzles, so it not only has a greater intrinsic reliability than an ordinary ink-jet printing system, but also is compatible with a wider variety of inks, including inks which have relatively high viscosities and inks which contain pigments and other particulate components. Furthermore, it has been found that acoustic printing provides relatively precise positioning of the individual printed picture elements ("pixels"), while permitting the size of those pixels to be adjusted during operation, either by controlling the size of the individual droplets of ink that are ejected or by regulating the number of ink droplets that are used to form the individual pixels of the printed image.

[0004] When an acoustic beam impinges on a free surface (i.e., liquid/air interface) a pool of liquid from beneath the radiation pressure which the beam exerts against the surface of the pool reaches a sufficiently high level to release individual droplets of liquid from the pool, despite the restraining force of the surface tension. Focusing the beam on or near the surface of the pool intensifying the radiation pressure it exerts for a given amount of input power. The basic principles of acoustic-ink printing are well known and the subject of numerous commonly assigned U.S. patents.

[0005] A specific benefit of acoustic-ink printing is the ability to generate droplets which are of a much smaller size than the orifice through which the droplets are ejected. It has been found that acoustic-ink printing can generate droplets which are a magnitude smaller in size than that of the orifice opening, and significantly smaller than existing conventional ink-jet printer systems. This allows an acoustic-ink printing system to generate high resolution images not previously obtainable, since a key factor in obtaining high resolution is depositing the smallest spot possible on a recording medium.

[0006] However,, in existing printing methods, both

for conventional ink-jet printing and acoustic ink printing, the present practice is to use fast penetrating inks (also known as fast drying or low surface tension inks) for aqueous ink-jet printing. The fast penetrating inks are those which will commonly penetrate into plain paper fiber in less than three seconds allowing the ink to spread quickly on the surface of the paper and also seep into the paper.

[0007] A benefit of using fast drying inks is in conjunction with color printers, in order to reduce inter-color bleeding which would commonly occur if using slow drying inks, also known as high surface tension inks.

[0008] Another benefit of using fast drying inks for color printing is that as the inks are laid down on the print medium (e.g. paper such as plain paper), when a second color ink is placed down on that location or adjacent thereto, the first laid down ink will not tend to be on the surface, i.e. it will already have been absorbed into the paper. Therefore, the second laid down ink will not run over the first ink. The fast penetrating ink wicks into the paper before the second color ink is jetted onto the same paper surface. Additionally, the penetration of the first ink is rapid enough that lateral migration into adjacent locations previously printed is reduced, thereby diminishing inter-color bleed, which would normally occur under conventional techniques of printing with slow drying inks.

[0009] However, there are several drawbacks to use of fast-drying inks. Particularly, by having the ink penetrate into the paper some portion of the colorant or dye is also transported into the paper. This results in low optical density of the printed materials and also greater show-through when viewing the paper from the non-printed side. Specifically, the more colorant which is moved into the paper lowers the amount of colorant which can be visualized by a viewer, since the fibers will block the colorant from view.

[0010] Existing conventional ink jet printing machines which use fast drying inks can expect to obtain 1.2 to 1.3 optical density, when using plain paper. This is compared to high quality xerography at 1.8 to 2.0 and photography at 2.1 to 2.3 optical density.

[0011] A drawback of backside show-through is the inability to do duplex printing. Particularly, since the use of fast drying ink will, in many cases, cause the ink to wick through to the opposite side of the paper, two-sided printing would not be possible, since the ink which shows-through to the opposite side would ruin the second print.

[0012] The fast penetration/wicking characteristic of fast-drying ink into the paper also has the effect of some lateral wicking depending on the surface topology of the paper. This causes a poor edge sharpness on printed lines and text.

[0013] high-edge-sharpness is desirable in any printer, with the typical goal being a laser-quality print. Color printers typically focus on the quality of the color reproduction and have less concern for edge definition.

Black ink-jet printers that can yield sharp edges on plain paper are inherently slow-drying. This means that a page will still be wet and smudgable when output unless substantial amounts of drying time and/or thermally assisted drying are provided. Acoustic ink printing is desirable for its ability to provide edge-sharpness, without ragged edges, since it can apply such small drops which allow for a high dots-per-inch value.

[0014] When color printing, inter-color bleed is reduced by the use of fast-drying inks. While fast-drying inks have lower edge definition, in existing systems, they are still used for color reproduction. Also for existing systems, a color printer might use a slow-drying ink for monochrome black text and graphics, and use fast-drying color inks for color reproduction. Under this use, it is common that the slow-drying of the black ink causes inter-color bleed when used with color inks in normal printing or it will require substantial drying time.

[0015] A key aspect of printing is to remove the liquid from the ink droplets deposited on the recording medium. For example, liquid can be removed from the ink and printed medium by a number of methods. One simple method is natural air-drying in which the liquid component of the ink deposited on the medium is allowed to evaporate without mechanical assistance resulting in natural drying. Another method is to send the printed substrate through a dryer to evaporate the liquid. In some cases a special paper is used in which the liquid is absorbed by a thin coating of absorptive material deposited on the surface of the paper. Blotting of the printed medium is also known.

[0016] In the case of natural drying, almost 100% of the liquid is absorbed into the paper and is then, over a long period of time, evaporated naturally. The absorption and de-absorption of water into and out of the paper, however, has some undesirable side effects, such as a long drying time, strike through, feathering at edges of the printed image, paper curl and paper cockle. In the case of paper cockle, the absorption and de-absorption of the water relaxes the internal stresses of the paper, resulting in cockle. Cockle is also a function of the amount of liquid deposited per liquid area. Less printing on a paper has less potential to develop cockle due to the small amount of liquid. More printing on a paper has more cockle potential due to a higher amount of liquid per unit area. Cockle can also be induced by heating the paper, which results in stress relief.

Summary of the Invention

[0017] In accordance with one aspect of the present invention there is provided an ink-jet printing apparatus for printing on a recording medium such as plain paper as well as other types of paper. The ink printing apparatus jets aqueous ink drops on the paper in the form of an image where the aqueous ink is a slow penetrating ink which does not penetrate the paper/paper fibers for a

relatively long time, on the order of greater than three seconds. Further provided is a drying system which allows for rapidly evaporating the water from the ink while the ink is still resident on the paper surface. The evaporation process is provided to substantially dry the initial ink before a second ink is jetted onto the paper at substantially the same, adjoining or other location. The evaporation or drying process is rapid enough to prevent the deposited ink from substantially migrating/wicking to any adjacent location of the paper which has or does not have ink laid thereon.

Brief Description of the Drawings

15 [0018]

FIGURE 1A is a cross-sectional view which shows a fast-drying ink which has been placed onto a paper surface;

20 FIGURE 1B is a cross-sectional view which illustrates the fast-drying ink on the paper surface of FIGURE 1A after a predetermined time period;

25 FIGURE 2A is a cross-sectional view which illustrates a slow-drying ink after it has been placed on a surface for a time period identical to the fast-drying ink of FIGURE 1A;

30 FIGURE 2B is a cross-sectional view which illustrates the slow-drying ink of FIGURE 2A on a surface of a paper for an identical time as the fast-drying ink of FIGURE 1B;

35 FIGURE 3 depicts a printer architecture for one embodiment of the invention;

FIGURE 4 illustrates a second embodiment of the invention; and

FIGURE 5 illustrates a third embodiment of the invention.

Detailed Description of the Preferred Embodiment

40 [0019] Turning now to the drawings, and at this point especially to FIGURES 1A-1B, there is shown a droplet of fast-drying ink (also known as low surface tension ink) 10 which has been placed on the surface of a recording medium such as paper 12, shown in cross-section. A fast-drying ink has certain attributes, among these are the characteristic of spreading out onto the surface of the paper, and quickly wicking or penetrating into fibers of paper 12 such that it passes through the surface 14 of paper 12. This spreading out includes a lateral migration, causing the ink to cover an area undesirably larger than the original circumference 16 of the deposited ink. FIGURE 1B shows the remaining colorant 10' of fast drying ink droplet 10 of FIGURE 1A after it has entered a substantially dry state due to removal of liquid in the droplet. As can be seen, the size of the remaining colorant 10' is substantially larger than the original size of the droplet placed onto the paper. Additionally, colorant 10' is shown to have seeped through to

the backside 18 of paper 12. This illustrates ink show-through which occurs when using fast-drying inks which quickly wick or penetrate into the fibers of the paper.

[0020] Turning to FIGURE 2A, depicted is a droplet of slow-drying ink (alternatively called high-surface tension ink) 20. Ink droplet 20 has been on paper 22 for the same amount of time as ink droplet 10 of FIGURE 1A. As can be seen, the high surface tension of this ink causes the droplet to have greater angles to the paper surface than that of droplet 10 of FIGURE 1A. Whereas a fast-drying ink such as in FIGURE 1A tends to have a penetration time of less than three seconds, a slow-drying ink will have a penetration time of greater than three seconds. Under the teachings of the present invention, ink droplet 20 is actively dried in a fast drying process to evaporate water from the droplet, leaving colorant 20' on the surface of paper 22 as shown in FIGURE 2B. As illustrated in FIGURE 2B, the colorant is substantially located on the surface of paper 22, and unlike the colorant of FIGURE 1B, has not spread out substantially past its circumferential area 24. In other words, the small droplets placed on the paper are inhibited from expansion, thereby maintaining the high resolution of the image.

[0021] Additionally, the colorant has not seeped into the interior of paper 22. The benefits of this are that the optical density of the color to a viewer will be much greater than that of FIGURE 1B's colorant, since the colorant of FIGURE 2B is not blocked by being held in the fibers of the paper. Further, since the size of the dried colorant is substantially the same circumference or size of droplet 20, it is possible to generate high-edge sharpness that is not achievable by use of the printing methods used in FIGURES 1A and 1B. Further, when an additional color is laid down on the same or other location of the paper, since the first color is already dried, inter-color bleeding is eliminated. Also, since the colorant has been maintained on the surface of paper 22, there is not colorant show-through on the backside of the paper.

[0022] Thus, FIGURES 2A and 2B illustrate characteristics of the present invention which employs concepts counter to those used in existing operations of liquid-ink printing. Particularly, it is the conventional belief that it is best, in color printing, to use fast drying inks which are absorbed by paper fibers in order to quickly dry the paper for a next application of ink. On the other hand, the present invention takes an opposite approach which is to keep the ink droplets on top of the paper and then actively dry the ink droplets by applying heat during the printing process. This maintains the ink droplets in a small uniform manner similar in size and shape to the original deposited drops, which in turn maintains the high-image resolution.

[0023] The present invention includes other improvements over existing systems. Since existing systems allow the ink to penetrate into the fibers, it is necessary to pull the moisture out of the fibers. In par-

ticular, they allow the moisture to come in the front surface of the paper, then they pull the moisture out from the back side of the paper through backside heating. This is an inefficient manner of removing the moisture.

5 The present invention heats the ink droplets by front-side heating prior to the liquid substantially entering into the fibers of the paper. Less energy is required in the present invention, because it is not necessary to un-wet the fibers, i.e. dry out the fibers and create new free energy fibers again. Thus, the front-side drying which is described below, is determined to be preferable when one wishes to increase the throughput of the printing machine.

[0024] For example, if ten pages a minute are to be printed, the machine will have only six seconds to print before the next sheet comes through so there will only be six seconds before it is necessary to take that sheet out and put another sheet of paper on top of it. This does not allow for passive drying but rather requires a 15 fast-active drying solution. Drying the ink on the same side on which it was deposited requires less energy when high-surface tension ink is used since the ink has not yet substantially entered the paper fibers. While the present invention could be performed with backside drying, such a configuration would slow the printing process.

[0025] Turning to FIGURE 3, illustrated is a first embodiment of a printing system implementing the concepts of the present invention. Printing system 30 includes an input tray 32 containing a supply of paper 34. The paper is moved out of input tray 32 into engagement with drum 36. Paper from input tray 32 may be preheated by preheat element 38 prior to engaging drum 36. In this embodiment drum 36 is a four-inch diameter drum at 60 C. It is to be appreciated drums with other characteristics may also be used.

[0026] Printheads 40, 42, 44 and 46 are located exterior to drum 36 in a fashion whereby droplets emitted from the printheads are deposited on paper 34. Ink 30 supply lines 48 supply ink from a supply source (not shown) to printheads 40-46. A curved carriage 50 is used for carrying printheads 40-46. Located within operational distance of drum 36 are dryers (heater) 52 and 54. In this embodiment, printhead 40 is a magenta 40 printhead, printhead 42 is a black printhead, printhead 44 is a yellow printhead, and printhead 46 is a cyan printhead. It is to be appreciated however, that the present invention would work in a single-color system such as a black system or a system having colors other than CMYK. Printer 30 is designed to produce 10 pages per minute. Printheads 40-46 are positioned in two banks of 40-42 and 44-46 around drum 36. In this embodiment, dryers 52, 54 are considered to be radiant heaters, however, other types of drying devices may be used, such as microwave, air, gas, reflective, conductive or other drying sources, which would allow for fast drying of the ink.

[0027] As paper 34 is moved by spinning drum 36,

first color printhead 40 jets ink onto paper 34, which then moves past dryer 52. Next, printhead 44 prints on the same, adjoining, or other paper location. Then paper 34, with the second color, is moved past and substantially dried by second dryer 54, during the first drum rotation. During the second drum rotation third color printhead 42, may print onto paper 34, and thereafter dryer 52 substantially dries this newly supplied ink. This process is repeated when fourth printhead 46 prints color which is dried by second dryer 54.

[0028] The heat applied to the ink drops enables printing with one color followed substantially immediately by an active evaporation/drying stage. Also, in this architecture, the amount of energy supplied to the dryer is adjusted according to the amount of ink just deposited by one of printheads 40-46, by computing image data for that printhead. Control of the output of dryers 52 and 54 is accomplished by controller 56. This method optimizes drying/evaporation of the ink on the paper and prevents under-drying (paper-cockle) or over-drying (paper scorch). Adjusting the amount of heat energy transmitted to a surface of a print medium is known in the art. Once the printer has completed its second rotation, the printed paper is deposited in output tray 57.

[0029] FIGURE 4 is a top view illustrating a second embodiment of the present invention designed to work in conjunction with a flat printing system 58, which includes printhead assembly 60 configured as a page-width array extending substantially the full width of recording medium such as paper 62. The paper is maintained in a stationary position as printhead assembly 60 is moved. Printhead assembly 60 includes printheads 64-70. Also carried on printhead assembly 60 are heaters 72 and 74. During a first pass in direction 76, one of selected printheads 64-70 lays down ink droplets. The ink being a slow-drying (high-surface tension) type ink. As this ink is jetted onto the paper surface, trailing dryer 72 dries the laid down ink. Upon passing in direction 78, the process is repeated with another printhead and use of dryer 74. Dryers 72 and 74 may be the radiant heaters or other drying devices discussed in connection with FIGURE 3.

[0030] Printhead 60 again moves in direction 76 and then direction 78, repeating the process of depositing ink droplets from remaining printheads 68 and 70, if necessary, and drying the ink droplets with the associated trailing heaters 72 and 74 as appropriate. It is to be appreciated, that an important aspect of this embodiment is that prior to the laying down of a subsequent high-surface tension ink from one of printheads 64-70, the heater elements 72 or 74 have substantially dried the just laid down ink. In this manner the same benefits achieved in the previous embodiment are accomplished. It is to be appreciated that while in this embodiment, the dryers 72, 74 are shown attached to the printhead assembly 60, they may be on a separate tracking assembly which allows them to dry ink droplets in the manner described above.

5 [0031] Further, ink is supplied to printhead assembly 60 through transmission lines 80 from an ink supply source (not shown). Further, a controller 82 is designed to supply the printhead assembly 60 with a desired data image to be printed and may also include (or as a separate controller not shown) a manner of determining the amount of ink a printhead will deposit on an image and thereby adjust the energy level of the appropriate heater 72 or 74. This concept is equally applicable to the embodiments shown in FIGURES 3 and 5.

10 [0032] Turning to FIGURE 5, illustrated is a third embodiment of the present invention for use with a partial width array type printing device 90 which is shown in side view. In this embodiment, recording medium 92 is printed on by partial width array printhead assembly 94 including printheads 96-102. Also carried on partial width array printhead assembly 94 are heaters 104 and 106. Printhead array 94 traverses reciprocally in directions 108 (going into the drawing sheet) and 110 (coming out of the drawing sheet). An example of operation for this embodiment includes applying ink from printhead 102 and drying of that ink substantially immediately thereafter by heater 104 while printhead is traversing in direction 108. Then when traversing in direction 110, where ink from printhead 96 is deposited, this ink is substantially dried by heater 106. Additional traversing along paths 108 and 110 are completed for the depositing of ink from printhead 100, dried by dryer 104, and depositing ink from printhead 98 which is dried by dryer 106, as appropriate. Thereafter, the recording medium is moved a preselected distance in direction 112, to continue the printing process to the end of recording medium 92. RF energy is supplied to the printheads through transmission lines 114, and the image to be displayed and control of the heat amount depending upon that image is provided by signals from controller 116.

Claims

40 1. A liquid printer (30) in which liquid ink (20) is deposited, in response to image data, on a recording medium (34) within a print zone, comprising:

45 A liquid printhead (40), disposed so as to operate within the print zone, to deposit liquid ink (20) on the recording medium (34) while in the print zone, in response to image data;

50 A high surface tension ink (20) being used as the liquid ink deposited on the recording medium (34); and

55 A drying apparatus (52,54), positioned in relationship to the ink printhead (40), to dry the high surface tension ink (20) deposited on a surface of the recording medium (34) before the high surface tension ink (20) is absorbed

into the recording medium (34).

2. A method of printing using a liquid ink printing device, comprising:

5

depositing a first high surface tension ink (20) on a recording medium (34);

drying the first high surface tension ink (20) prior to the first high surface tension ink being 10 absorbed into the recording medium (34);

depositing a second high surface tension ink (20) on the recording medium, after the first high surface tension ink has been substantially 15 dried; and

drying the second high surface tension ink (20) prior to the second high surface tension ink (20) being absorbed into the recording medium 20 (34).

3. The method according to claim 2, further including:

sensing an amount of the first and/or second 25 high surface tension ink (20) being deposited on the recording medium (34); and

adjusting an amount of a drying energy (52,54) supplied to the first and/or second high surface 30 tension ink (20) dependent upon the sensed amount.

35

40

45

50

55

FIG. 1A

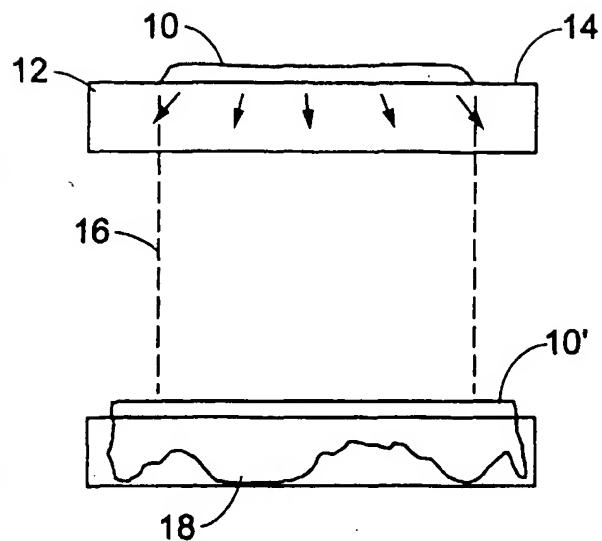


FIG. 1B

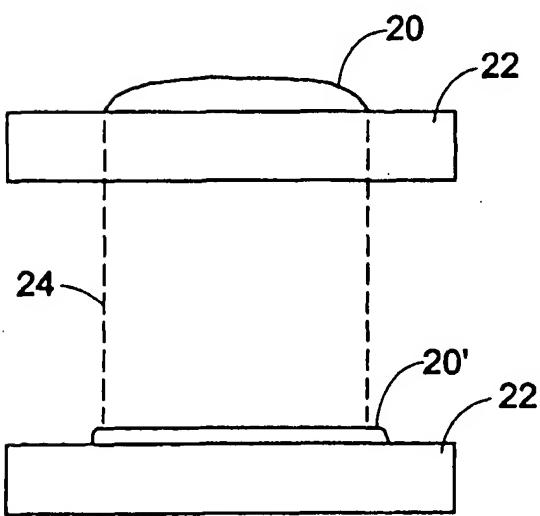


FIG. 2A

FIG. 2B

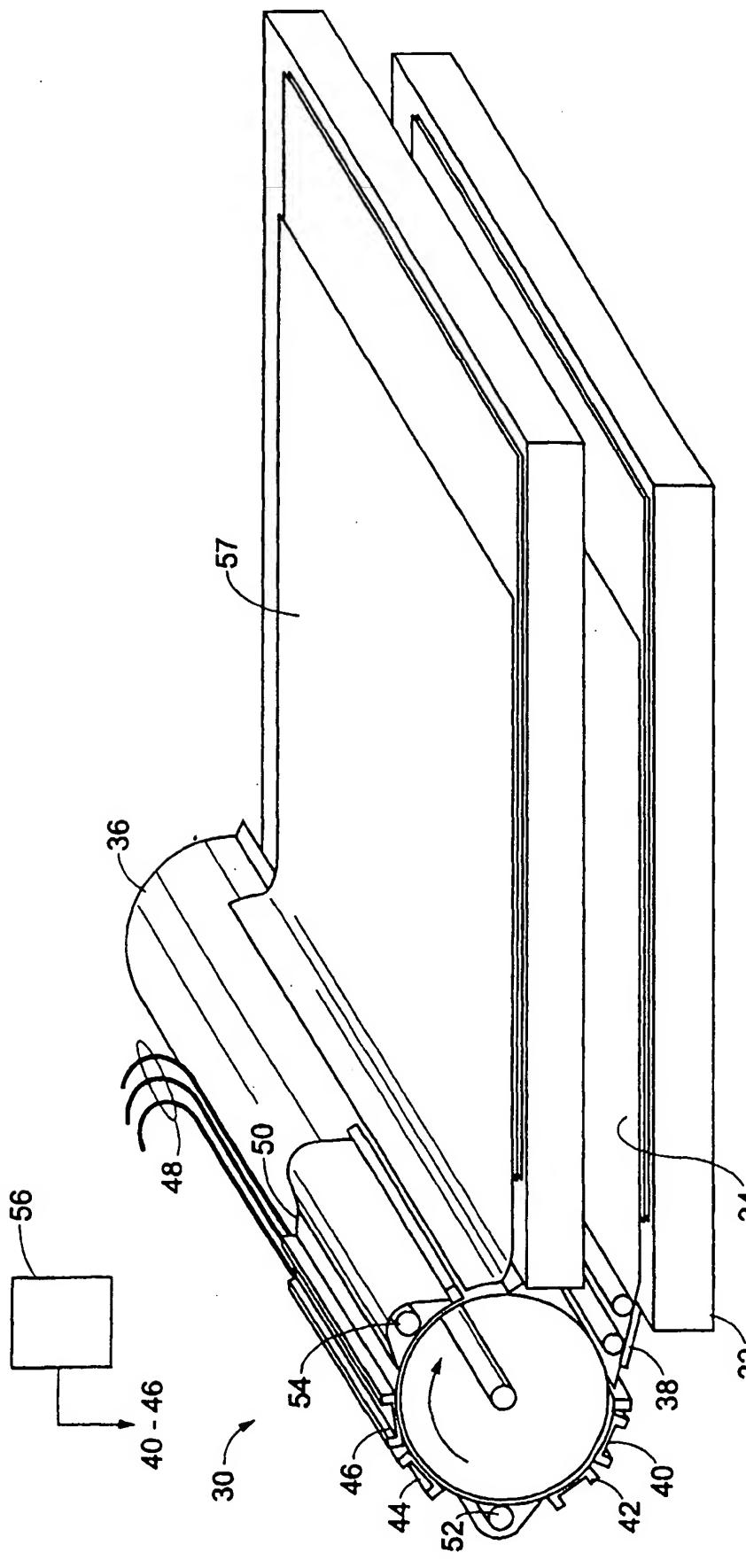
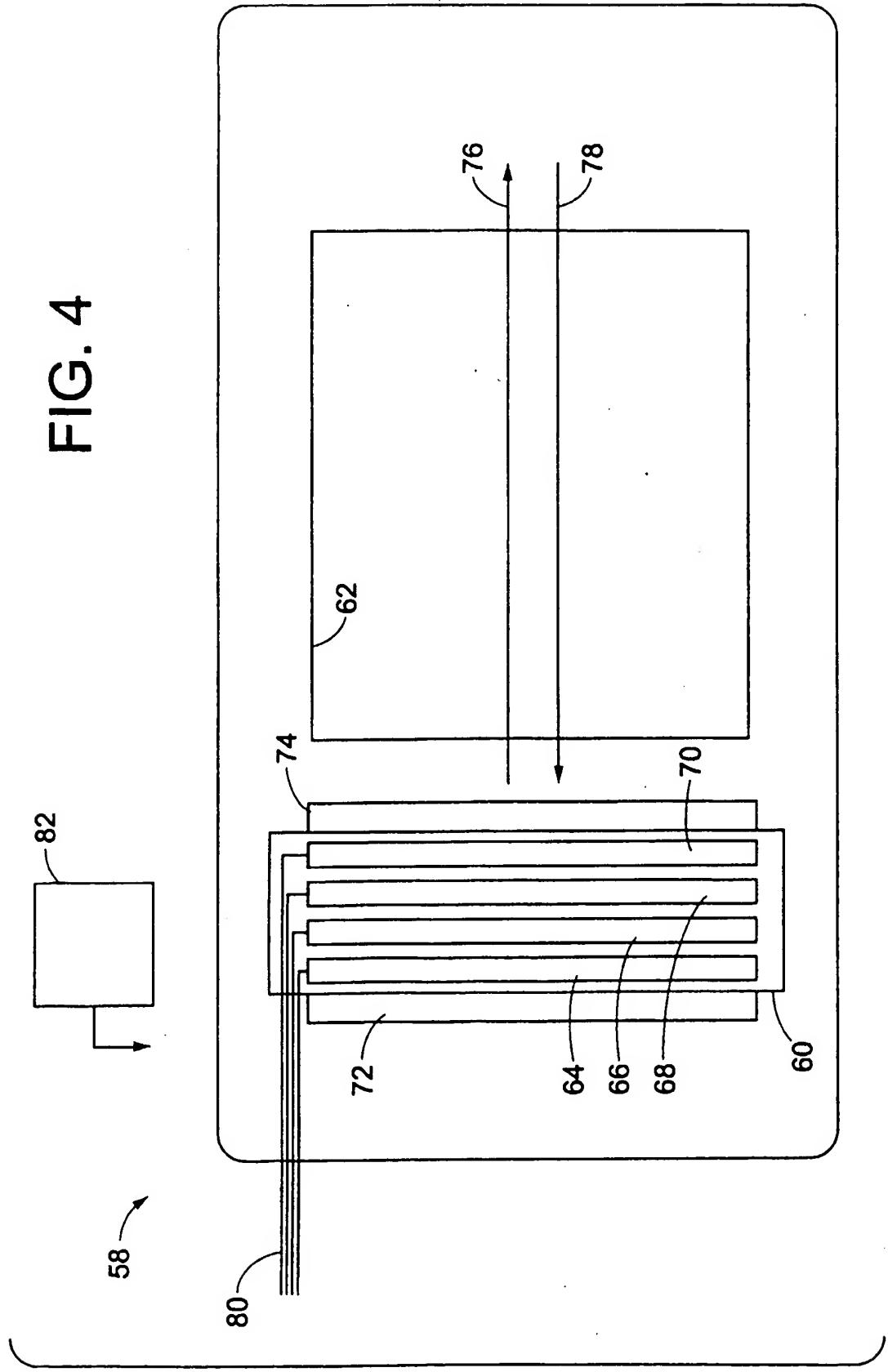


FIG. 3

FIG. 4



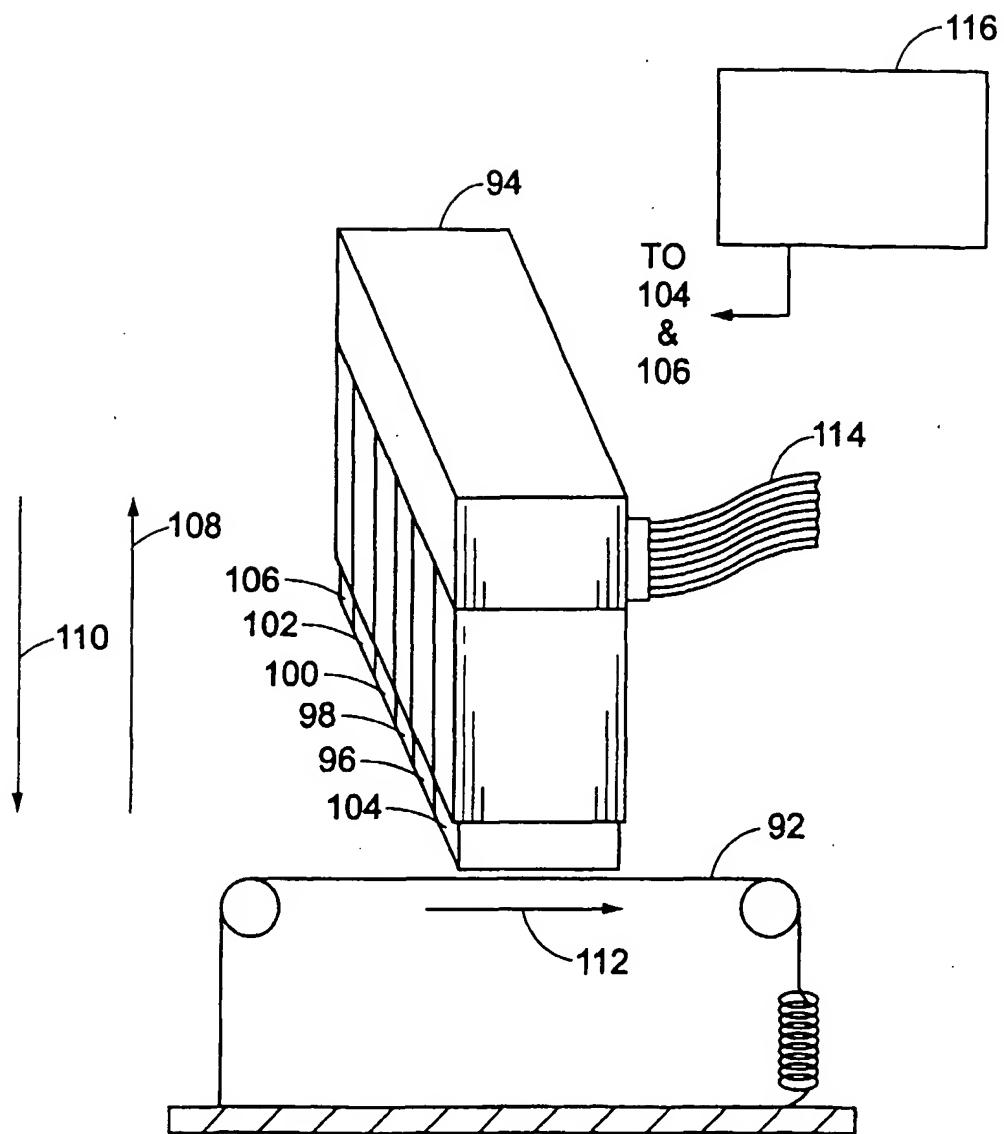


FIG. 5



(19)

Europäisches Patentamt

European Patent Office

Office europ en des brev ts



(11)

EP 1 070 596 A3

(12)

EUROPEAN PATENT APPLICATION

(88) Date of publication A3:
04.04.2001 Bulletin 2001/14(51) Int. Cl.⁷: B41J 11/00(43) Date of publication A2:
24.01.2001 Bulletin 2001/04

(21) Application number: 00115238.8

(22) Date of filing: 13.07.2000

(84) Designated Contracting States:
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU
MC NL PT SE

Designated Extension States:

AL LT LV MK RO SI

(30) Priority: 19.07.1999 US 357015

(71) Applicant: Xerox Corporation
Rochester, New York 14644 (US)

(72) Inventors:

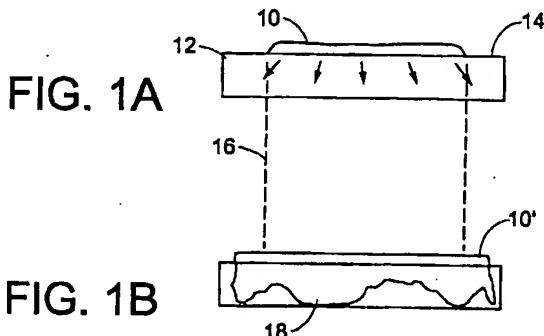
- Roy, Joy
San Jose, California 95138 (US)
- Hadimioglu, Babur
Mountain View, California 94040 (US)

- Ellison, Richard N.
Palo Alto, California 94306 (US)
- Sprague, Robert
Saratoga, California 94303 (US)
- Kruger, James B.
Half Moon Bay, California 94019 (US)
- Lennon, John
Newark, California 94560 (US)

(74) Representative:
Grünecker, Kinkeldey,
Stockmair & Schwanhäusser
Anwaltssozietät
Maximilianstrasse 58
80538 München (DE)

(54) A method for achieving high quality aqueous ink-jet printing on plain paper at high print speeds

(57) An apparatus 30 for ink-jet printing on a recording medium 34 is provided which includes the steps of jetting aqueous ink drops 40 on the recording medium 34 (paper) in the form of an image. The aqueous ink used is a slow-drying (high-surface tension) ink 20 which does not penetrate the paper/paper fibers 34 for a relatively long time. Prior to penetration of the paper/paper fibers 34, the water in the droplet is quickly evaporated from the ink while still resident on the paper surface. The evaporation process is substantially completed prior to an additional liquid ink 20 being jetted 40 onto the same or adjoining location of the recording medium. The evaporation is rapid enough to prevent the resident ink from substantially migrating/wicking to any adjacent location or into the recording medium. Further drying energy (52, 54) is transferred to the resident ink spots from the same direction as the printheads ensuring less energy requirement.





European Patent
Office

EUROPEAN SEARCH REPORT

Application Number

EP 00 11 5238

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.)
X	US 5 570 118 A (DUDEK LESLEY P ET AL) 29 October 1996 (1996-10-29) * abstract *	1	B41J11/00
A	* column 5, last paragraph - column 6, paragraph 2; figure 1 *	2	
X	DE 36 42 204 A (SEIKO EPSON CORP) 11 June 1987 (1987-06-11) * claim 1 *	1	

TECHNICAL FIELDS SEARCHED (Int.Cl.)			
B41J			
<p>The present search report has been drawn up for all claims</p>			
Place of search	Date of completion of the search	Examiner	
THE HAGUE	13 February 2001	Wehr, W	
CATEGORY OF CITED DOCUMENTS		T : theory or principle underlying the Invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document			

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 00 11 5238

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on. The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

13-02-2001

Patent document cited in search report		Publication date		Patent family member(s)		Publication date
US 5570118	A	29-10-1996		US 5371531 A		06-12-1994
				BR 9502579 A		28-05-1996
				US 5885686 A		23-03-1999
				BR 9304692 A		17-05-1994
				MX 9306662 A		31-05-1994
DE 3642204	A	11-06-1987		JP 62167054 A		23-07-1987
				JP 62199448 A		03-09-1987
				JP 2590822 B		12-03-1997
				JP 62288042 A		14-12-1987
				JP 2004876 C		20-12-1995
				JP 7025163 B		22-03-1995
				JP 62135369 A		18-06-1987
				JP 62144977 A		29-06-1987